

Work Order ID 147867

Friday, June 17, 2016 8:22:32 AM

147867

Page 1

Item ID: D5152-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Post Mount
 Start Date: 6/17/2016 Start Qty: 800 ***8*** Cust Item ID:
 Required Date: 6/22/2016 Req'd Qty: 800 ***8*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: JUN 17 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5152	B								
110	FLOW WATER JET	0.00							
110									
Waterjet	Memo	0.13							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>B</u> Prog Rev: <u>B</u>								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.01							
Quality Control									
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.03							
Quality Control									

DAS
38
9-89
JUN 29 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Friday, June 17, 2016 8:22:32 AM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 6/17/2016 **Start Qty:** 8.00 ***g***

Required Date: 6/22/2016 **Req'd Qty:** 8.00 ***O***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

134

0.00

134

Small Fab

Memo

0.17

Small Fab

FROM ON MANUAL ROLLER OR ON BRAKE AS PER DWG

DAS
30
9-89

JUL 01 2016

136

QC5- Inspect part completeness to step on W/O	0.00
---	------

136

QC

Memo

0.03

Quality Control

DAS
38
9-89

JUL 04 2016

140

Identify as per dwg & Stock Location:_____ 0.00

140

Packaging

Memo

0.01

Packaging

LOCATION: WA002

DATE
6
9-23

Jul 06 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 147867

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147867

Page 3

Item ID: D5152-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Post Mount
Start Date: 6/17/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 6/22/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.13							
Quality Control									

DAS
21
9-89

JUL 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																							
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Picklist Print

Friday, June 17, 2016 8:22:35 AM

Page 1

Work Order ID: 147867

147867

Parent Item: D5152-1

D5152-1

Parent Item Name: Fwd Post Mount

Start Date: 6/17/2016

Required Date: 6/22/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 14.09.04 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased	No				sf	204.1935		0.757895			
M304S18GA									**				
304/316 .050 Sheet												06/16/2016	

Location	Loc Qty	Loc Code
MAT020	154.124	
M133328	55.224	
M133587	2.9	
M134982	96	
MAT20	39.3	
M134580	39.3	
TPI	10.76946	
M134604	10.76946	
134824		

1.7

DQA: _____ Date: _____



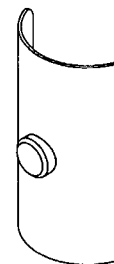
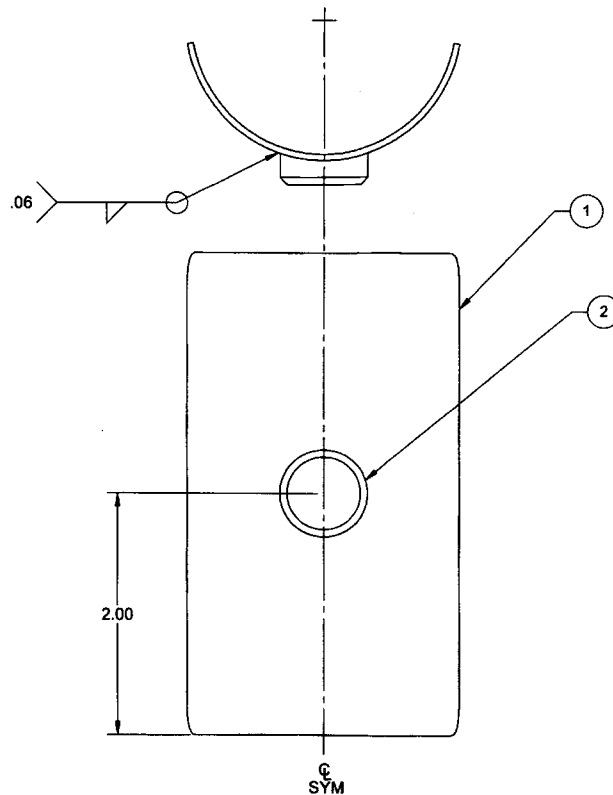
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework Scrap Use-as-is Suspected Unapproved		AGAINST DEPARTMENT/PROCESS Skid-tube Machining Thermoforming Large Fab Cross tube Small Fab Finishing Composite Water Jet Prod. Eng. Coord. Rec/Store/Packaging Supplier Engineering Quality Other					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment Design Doc/Data Equip/Tooling Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified No Re-verification Operator Offset/Setup Supplier Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due		FAULT CATEGORY Pressure/Forced Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter Temperature/Cure Set-up BOM/Route Broken/Damage/Defect Inspection Incomplete/Unqualified Contamination Countersink Cut Too Short Instructions Incomplete/Unclear Drill Holes Power Loss/Surge Folio/Program Grain Weld Wrong Stock Pulled Out of Sequence Off-set Mislabeled Fit/Function Misaligned/off center Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence							
		OTHER :							

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5152-041	FWD POST MOUNT ASSY
1	1	D5152-1	FWD POST MOUNT
2	1	D5152-5	FWD STEP POST



SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
PART TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

147-867-MLS

1606-17

RELEASED

2015 FEB 09

ECN 15-516 9

D5152-041 FWD POST MOUNT ASSEMBLY

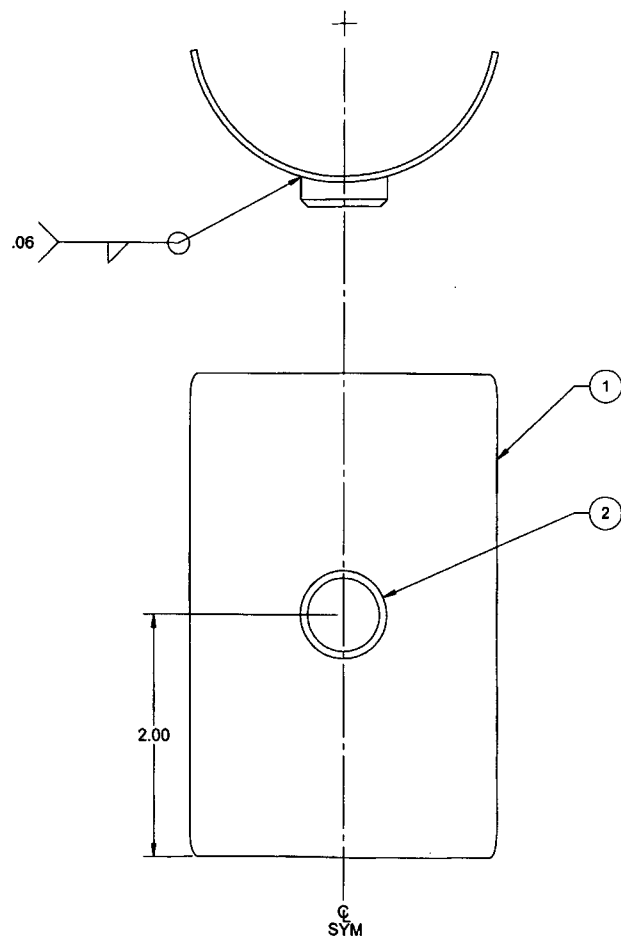
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D5152-041= 0.21 lbs

B	COMPLETE REDESIGN, SEE PREVIOUS REV FOR DETAILS	DB	15.01.09
A	NEW ISSUE	DB	14.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	POST MOUNT	NTS
DATE	15.01.09	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5152-043	AFT POST MOUNT ASSY
1	1	D5152-3	AFT POST MOUNT
2	1	D5152-7	AFT STEP POST



D5152-043 AFT POST MOUNT ASSEMBLY

RELEASED

2015 FEB 09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIME PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: D5152-043= 0.23 lbs

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 2 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	POST MOUNT	NTS
DATE	15.01.09	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

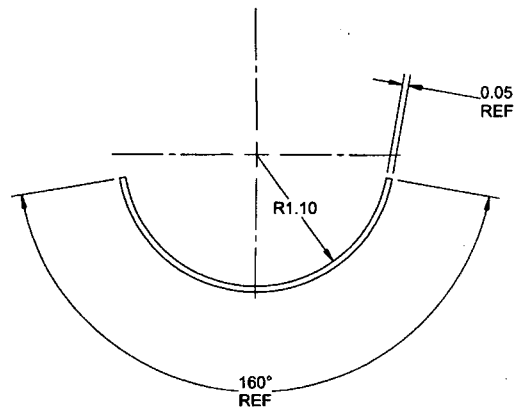
8 7 6 5 4 3 2 1

D

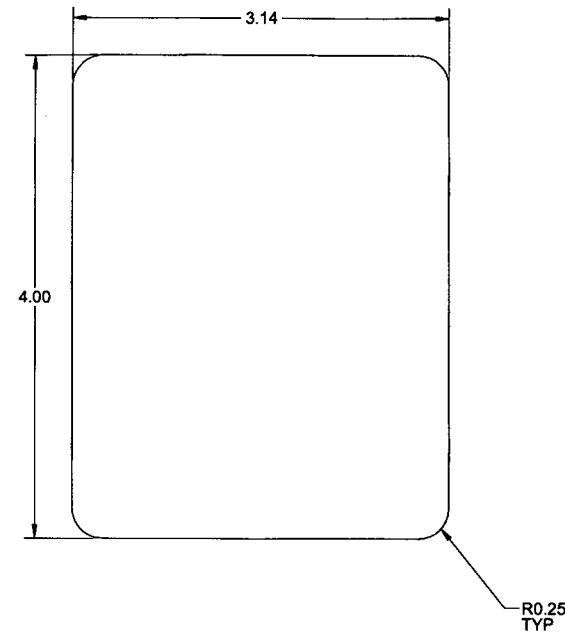
C

B

A



D5152-1 FWD POST MOUNT
(MAKE FROM D5152-1F)



D5152-1F FWD POST MOUNT
(FLAT PATTERN)

RELEASED

2015 FEB 09
49

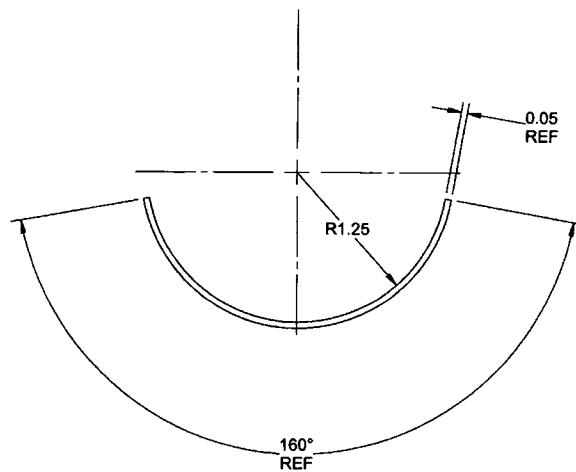
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

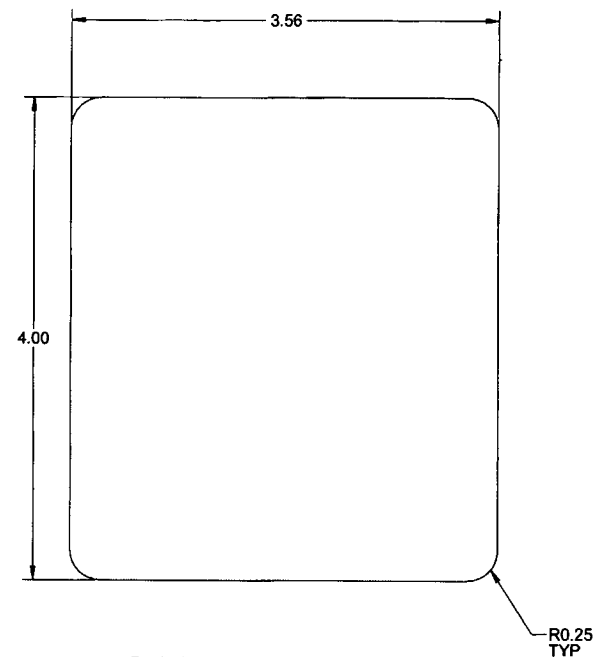
APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	POST MOUNT	NTS
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D5152-3 AFT POST MOUNT
(MAKE FROM D5152-3F)



D5152-3F AFT POST MOUNT
(FLAT PATTERN)

RELEASED

2015 FEB 09

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240, 0.050" THICK (PER DART SPEC M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO. D5152	REV. B
MFG. APPR.	DD		SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
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R1.150

0.20

0.06 X 45° CMF

Ø0.725

D5152-5 FWD STEP POST

R1.300

0.20

0.06 X 45° CMF

Ø0.725

D5152-7 AFT STEP POST**RELEASED**

2015 FEB 09

NOTES:

- 1) MATERIAL: AISI 304/316 SS ROUND BAR PER ASTM A276, REF DART SPEC M304R0.750
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

APPROVED

DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	EPDMA		
CHECKED	DB	DRAWING NO.	REV. B
MFG. APPR.	DD	D5152	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	POST MOUNT	NTS
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